



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

005082

D350-567-145
Job Sheet 181954



Part No: D350-567-145

Job Qty: 1 ea

Part Name: Floor Window Close Out (AS350 B3e)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/14/18

Job Tracking No:

Due Date: 10/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/9/18	10/9/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 21 2018
110	Packaging	1 pcs	10/9/18	10/9/18	0.00	0.00	Packaging1-3		AUG 27 2018
120	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC4		69 9-89
130	Packaging	1 pcs	10/9/18	10/9/18	0.00	0.00	Packaging3-1		DAS 69 9-89
135	DC	1 pcs	10/9/18	10/9/18	0.00	0.00	DC		DAS 69 9-89
140	QC21-FG	1 Ea	10/9/18	10/9/18	0.00	0.00	QC21		21 9-89

Part Op 130 - Identify and pack for shipping as per PPP D350-567-145 Location:FG033
Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-567-145 CHG001

9-89 DAS AUG 27 2018
21 9-89 AUG 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	90-Start up Operation	5056462
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	PM137307
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	5067896X1 5089346X1
CB200	Acrylic Adhesive, 3.5G	1 pcs (1 ea)	90-Start up Operation	5078157 DAS
D3802-1-024"	Window Seal (\$ Per Foot)	1 2 Ea (2 ea)	90-Start up Operation	5104211 68
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	5078339 9-89
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5083017
D4441-1-024"	Rubber Seal	1 2 ft (2 ea)	90-Start up Operation	5092107
D4730-020-030	Velcro Strip 2.0W/ X 3.0L	1 Ea (1 ea)	90-Start up Operation	5071942
D4971-041	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5084657
D5076-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5082779
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	5049834X1 5095637X1
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5044234
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	5089345
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	5071352
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	5067268
NAS1149F0332P	Washer	10 Ea (10 ea)	90-Start up Operation	5103666
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	5064085
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	5117316-25

Job Allocations

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Approved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		
Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐																																
Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐																																
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐																																
Large Fab	☐	Composite	☐	Supplier	☐																																		
Date :		QTY Effective :				MRB (QSI042) Approval																																	
Description						Completed By																																	
						Lead hand / Supervisor Approval Verification																																	
						QC / QA Coordinator Approval																																	

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Open ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Inspection ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		er Loss/Surge ☐ o/Program ☐ ain ☐ eld ☐ /rong Stock Pulled ☐ ut of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
---	--	--	--	---	--	---	--	--	--	---	--

OTHER : _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hwy 104, ON L6A 1K7
CANADA
TEL: 1 613 832-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S103984

Part: D350-567-145

Job No: 181954

Serial No/Batch: S103984

Revision:

Inspector:

Exp Date:

Instructions:

TC STC SH92-18 Issue 6

FAA STC SH989NE 09/06/30, FAA STC

Operation
90-Start up Operation

Component Part	Required	Inventory	Allocated
AN3-3A	5	484	0
AN525-10R6	2	172	0
AN525-832R7	2	119	0
CB200	1	28	0
D3802-1	2	40	0
D4435-9	2	6	0
D4436-041	1	8	0
D4441-1	2	566	0
D4730-020-030	1	17	0
D4971-041	1	3	0
D5076-041	1	1	0
MS21042L06	7	158	0
MS21042L08	2	3,152	0
MS21042L3	5	4,267	0
MS21059L3	2	308	0
MS35206-229	7	123	0
NAS1149F0332P	10	882	0
NAS1149FN616P	14	257	0
NAS1149FN816P	2	196	0

Part Specifications

Specifications could not be found.

Plex 8/14/18 8:52 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

REFERENCE ONLY